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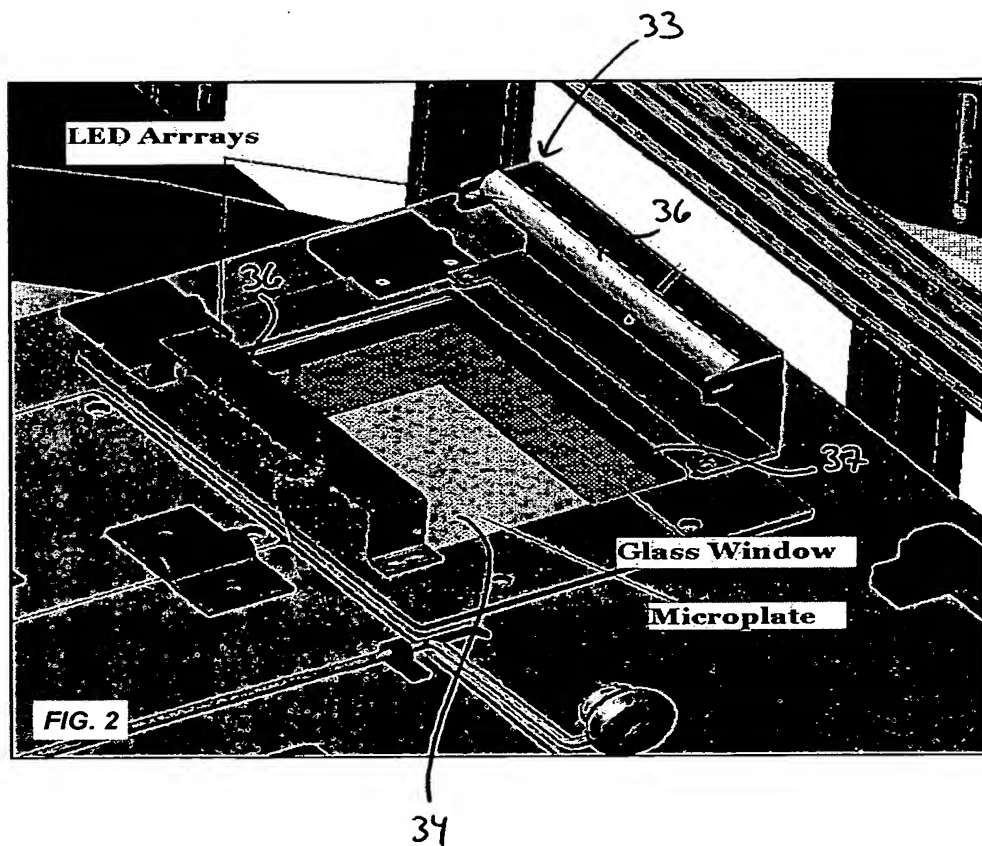
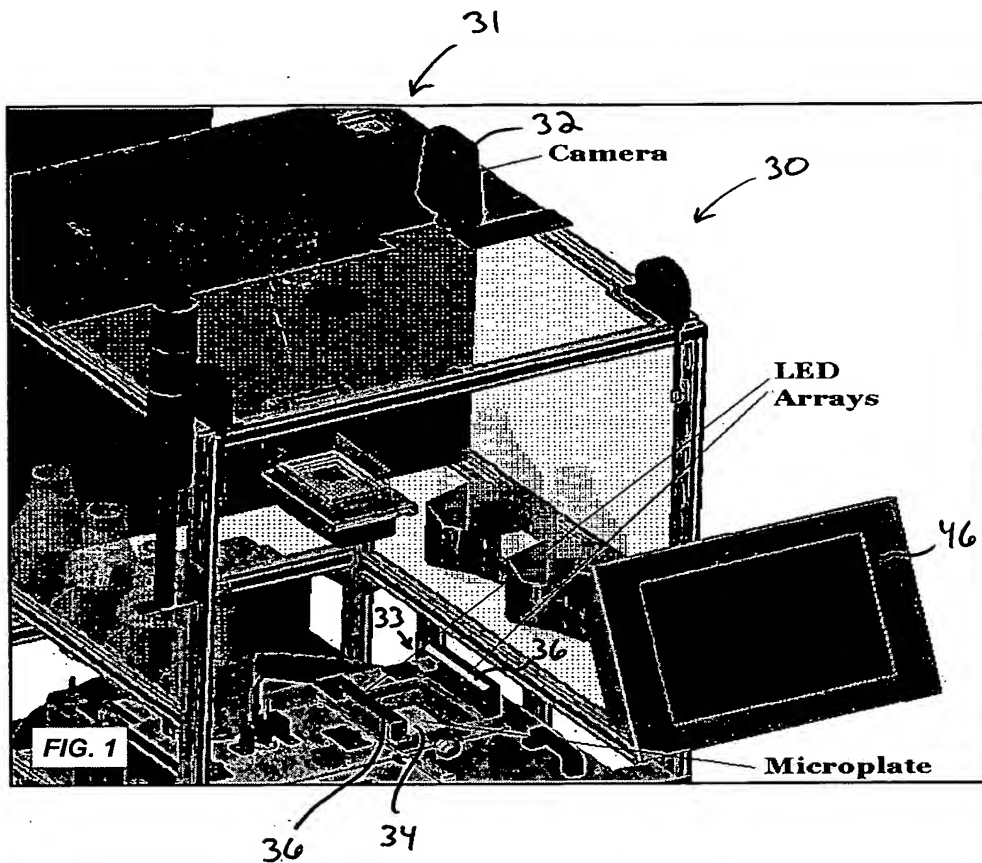
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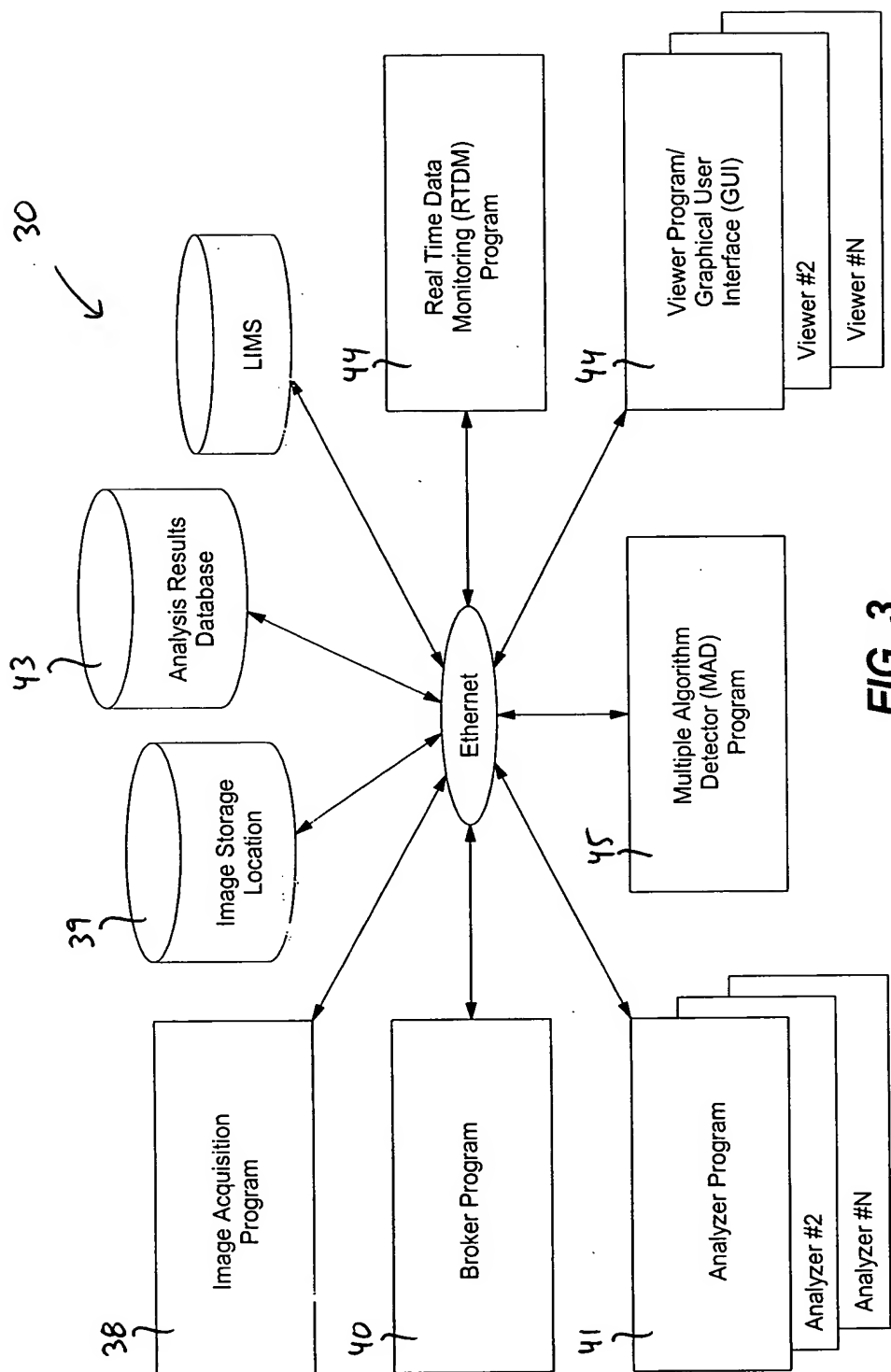
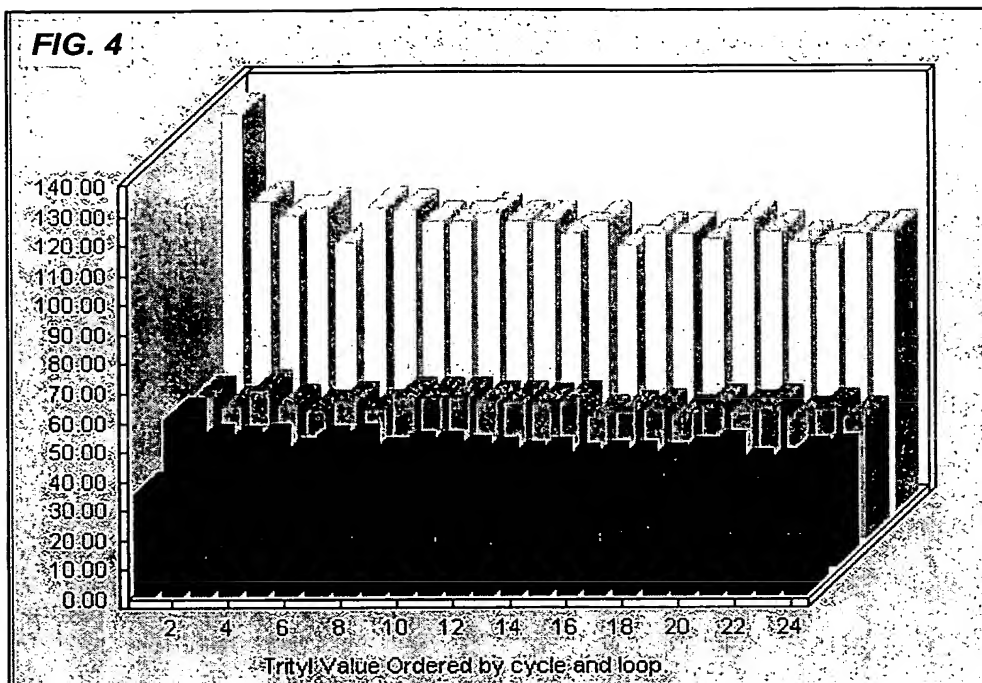
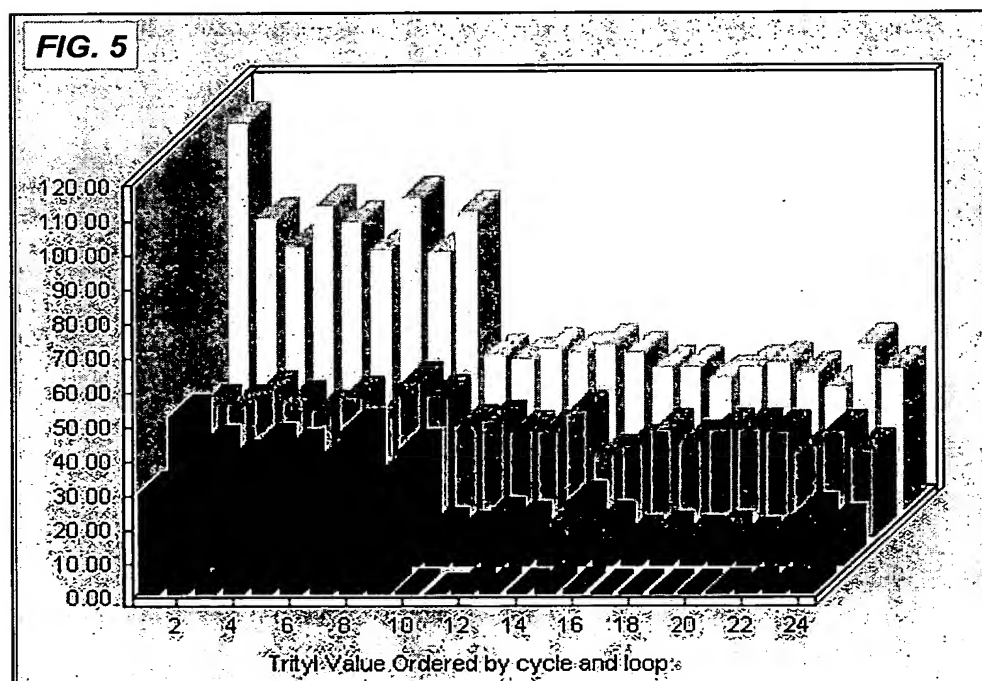


FIG. 3

**FIG. 4**



**FIG. 5**



Machine 1 - Plate 4 - Cycle Number 12

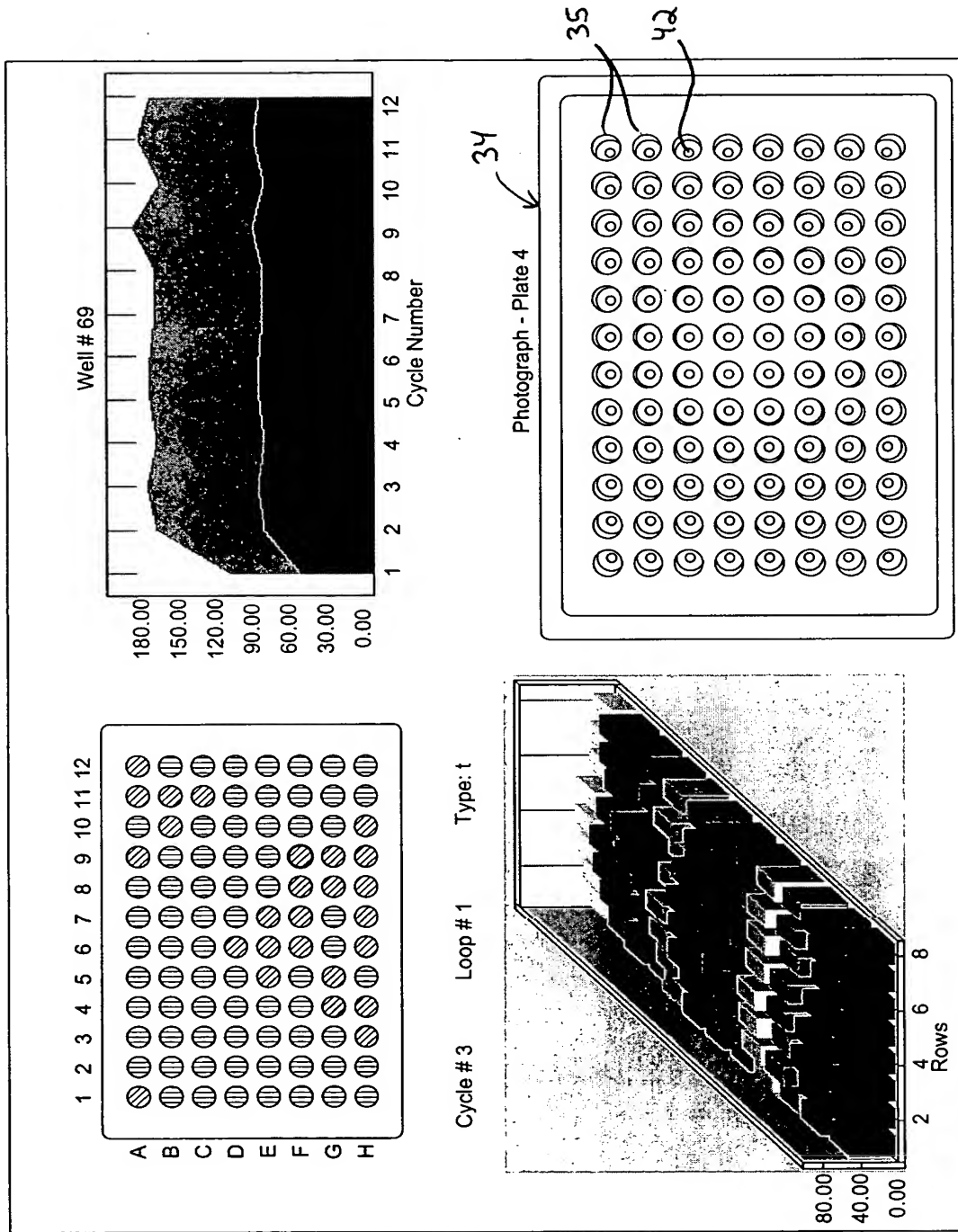


FIG. 6

Oligonucleotide  
Manufacturing  
Real Time Monitoring  
Graphical User Interface

Disconnect

Real Time Mode

Refresh Data

Status: Connected...

Machine ID

Type

Batch #

Restarts

Cycle #

Total Cycles

Start Time

Failures

Progress

Machine #1

Type 1

123456

0

0

Unknown

0

0%

Machine #2

Type 1

123457

0

0

Unknown

0

0%

Machine #3

Type 2

123458

1

19

75

2:30

9

25%

Machine #4

Type 2

123459

0

14

34

3:45

200

41%

Machine #5

Type 2

123460

0

21

34

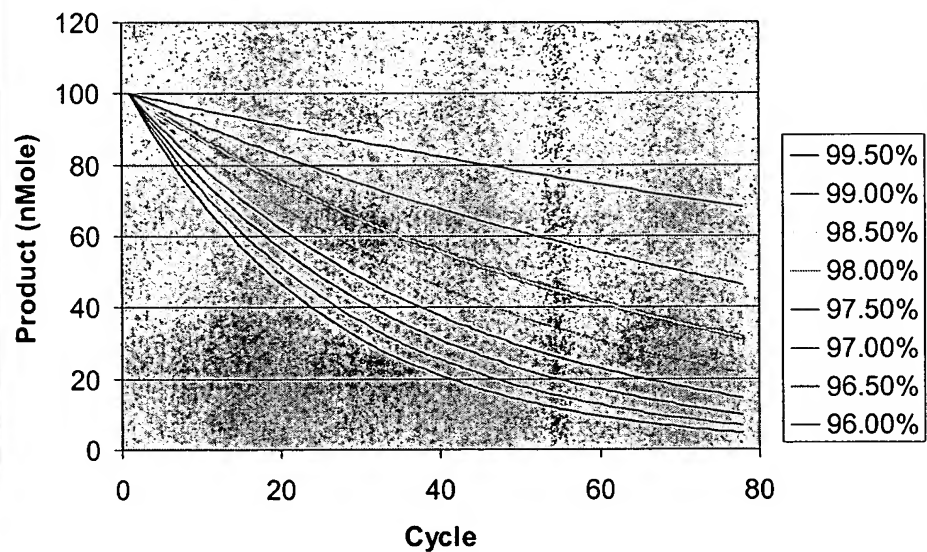
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1

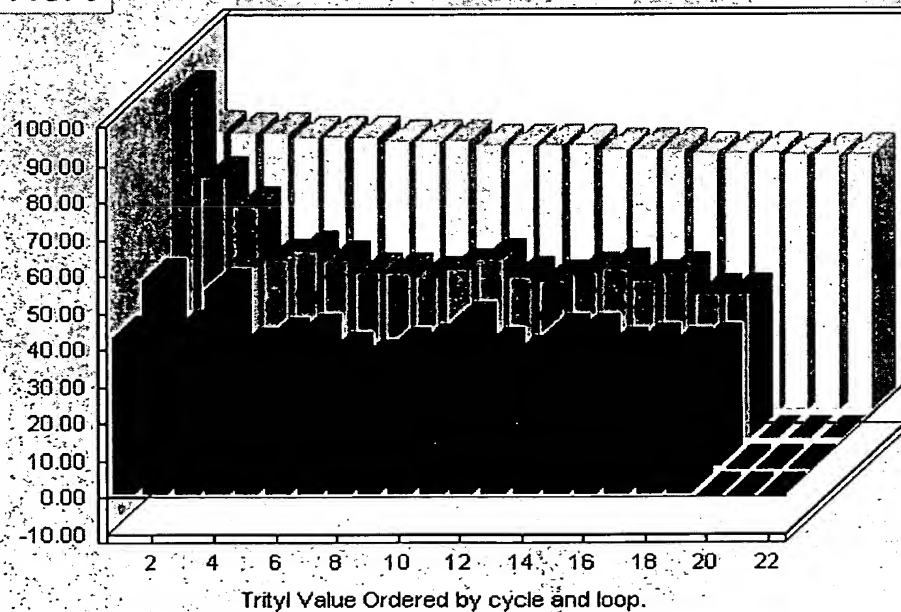
61%

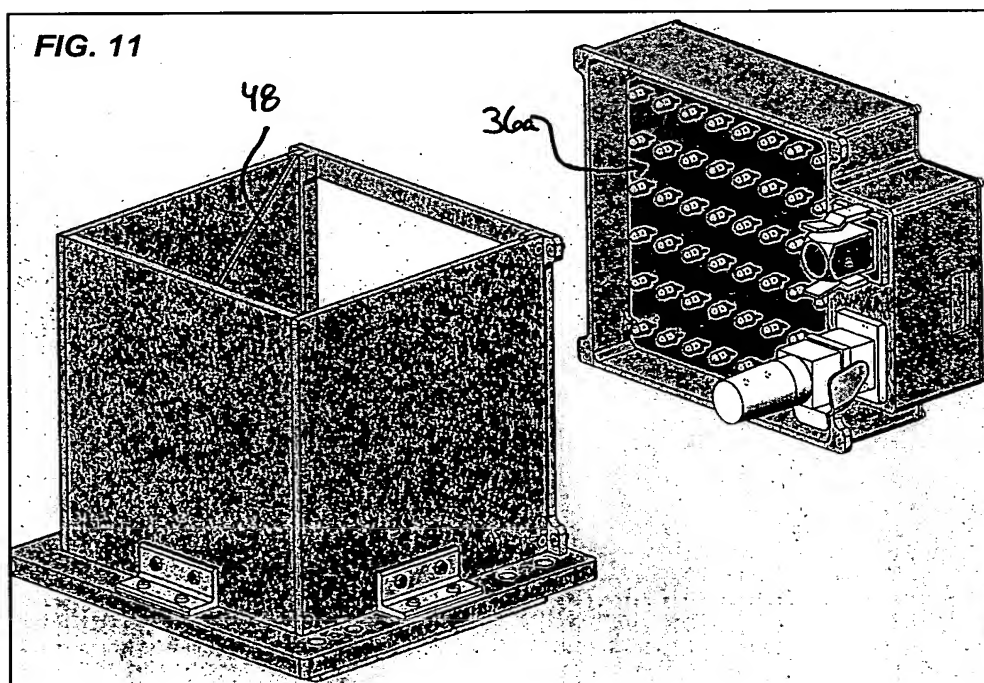
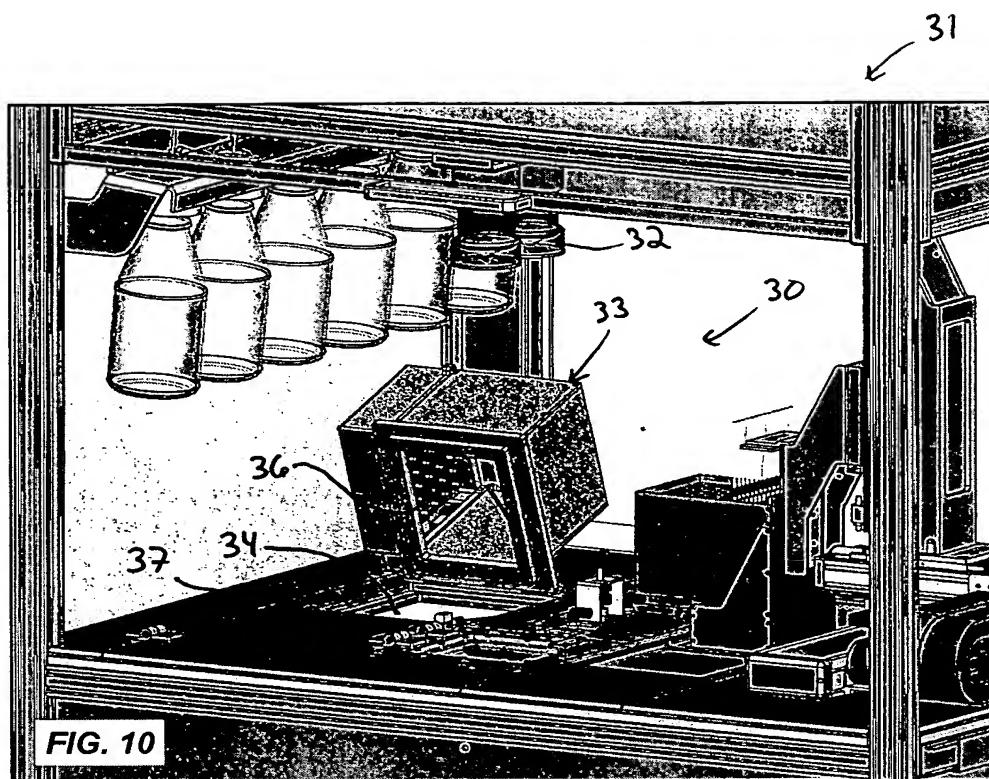
FIG. 7

**FIG. 8** Yield for diminishing coupling efficiencies

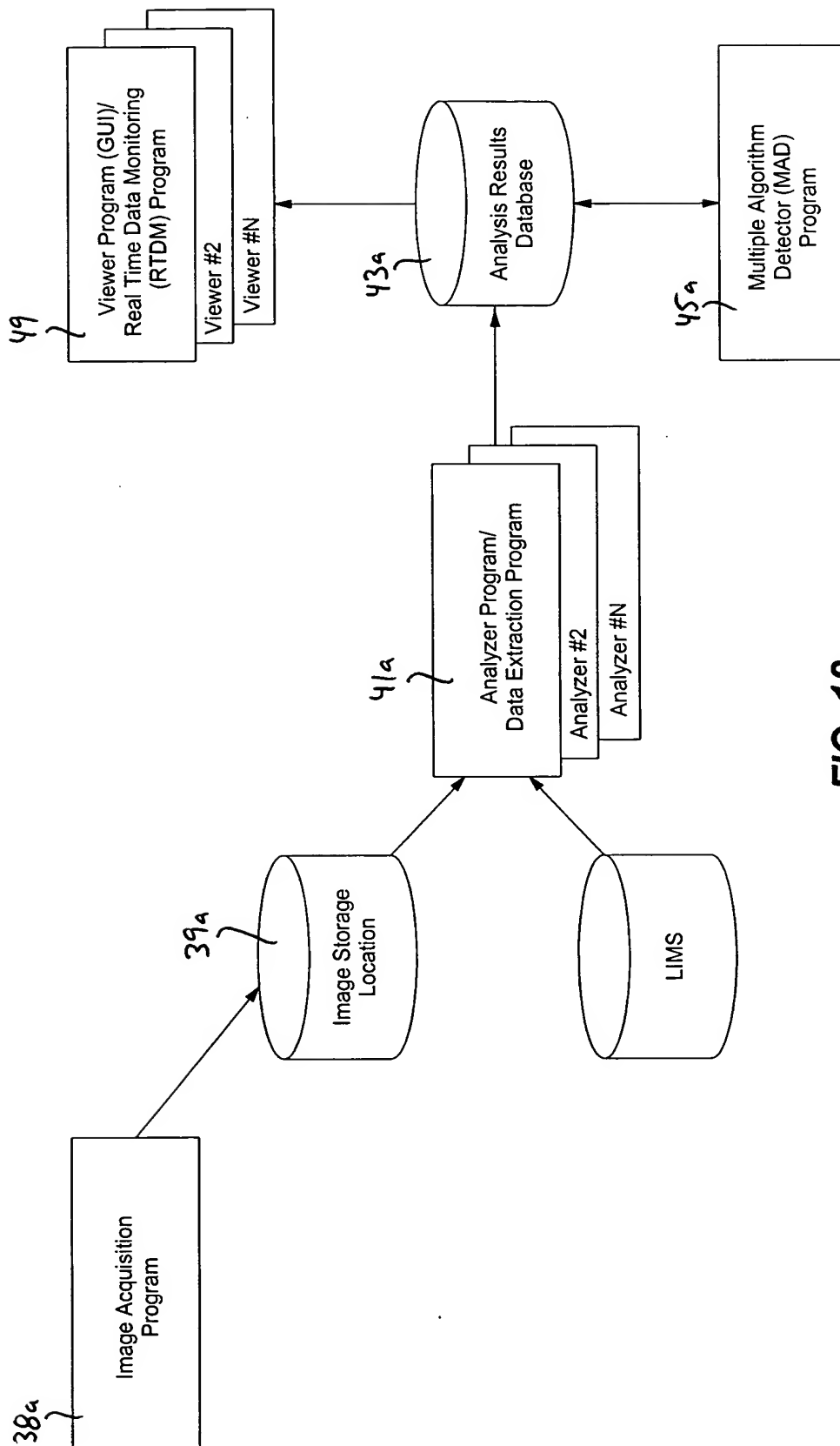


**FIG. 9**









**FIG. 12**